

5/12

|   |                     |             |
|---|---------------------|-------------|
| <b>DART AEROSPACE LTD</b>                 | <b>Work Order:</b>  | 22464       |
| <b>Description:</b> Wheel Shaft (R22/R44) | <b>Part Number:</b> | D3357-1     |
| <b>Dwg:</b> D3357 Rev. A page 1           | <b>Qty:</b>         | 70          |
|   |                     | Page 1 of 1 |

| Step | Location | Procedure  | By                      | Date     | Qty |
|------|----------|--|-------------------------|----------|-----|
| 1    | DC       | Issue Traveler   | [Signature]             | 05.02.16 | 20  |
| 2    | MC       | Turn as per Folio FA503 and Dwg D3357<br>Material: AISI 303 SS Hex Bar 0.625"<br>(M303H0.625)<br><b>Identify for D3357-1</b> | Batch: B15267<br>M16657 | 05.02.24 | 20  |
| 3    | QC2      | Inspect parts as they come off the CNC machine<br><b>Identify as D3357-1</b>   | [Signature]             | 05.02.25 | 20  |
| 4    | QC8      | Second check   | [Signature]             | 05.03.03 | 20  |
| 5    | MC       | Deburr   | [Signature]             | 05.03.03 | 20  |
| 6    | QC5      | Inspect work to Step 5   | [Signature]             | 05.03.03 | 20  |
| 7    | ST       | Identify and Stock   | [Signature]             | 05.03.04 | 20  |
| 8    | AC       | Cost / part 13.39  | SAC                     | 05.03.08 | 20  |
| 9    | DC       | Close W/O 13.39<br>Inspect Level 21  | [Signature]             | 05.03.09 | 20  |

| Rev | Date     | Change    | Revised By | Approved    |
|-----|----------|-----------|------------|-------------|
| A   | 05.02.03 | New issue | KJ/JLM     | [Signature] |

PRELIMINARY ISSUE

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                 |                          |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Mfg / Design<br>Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                 |                          |
|      |      |                    |    |      |     |                                 |                          |

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                  |                |                           |                        |                          |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                  |                | Verification<br>Section C | Approval<br>Design Mgr | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Design Mgr       | Action Description<br>Design Mgr | Sign &<br>Date |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |
|      |      |                                  |                             |                                  |                |                           |                        |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

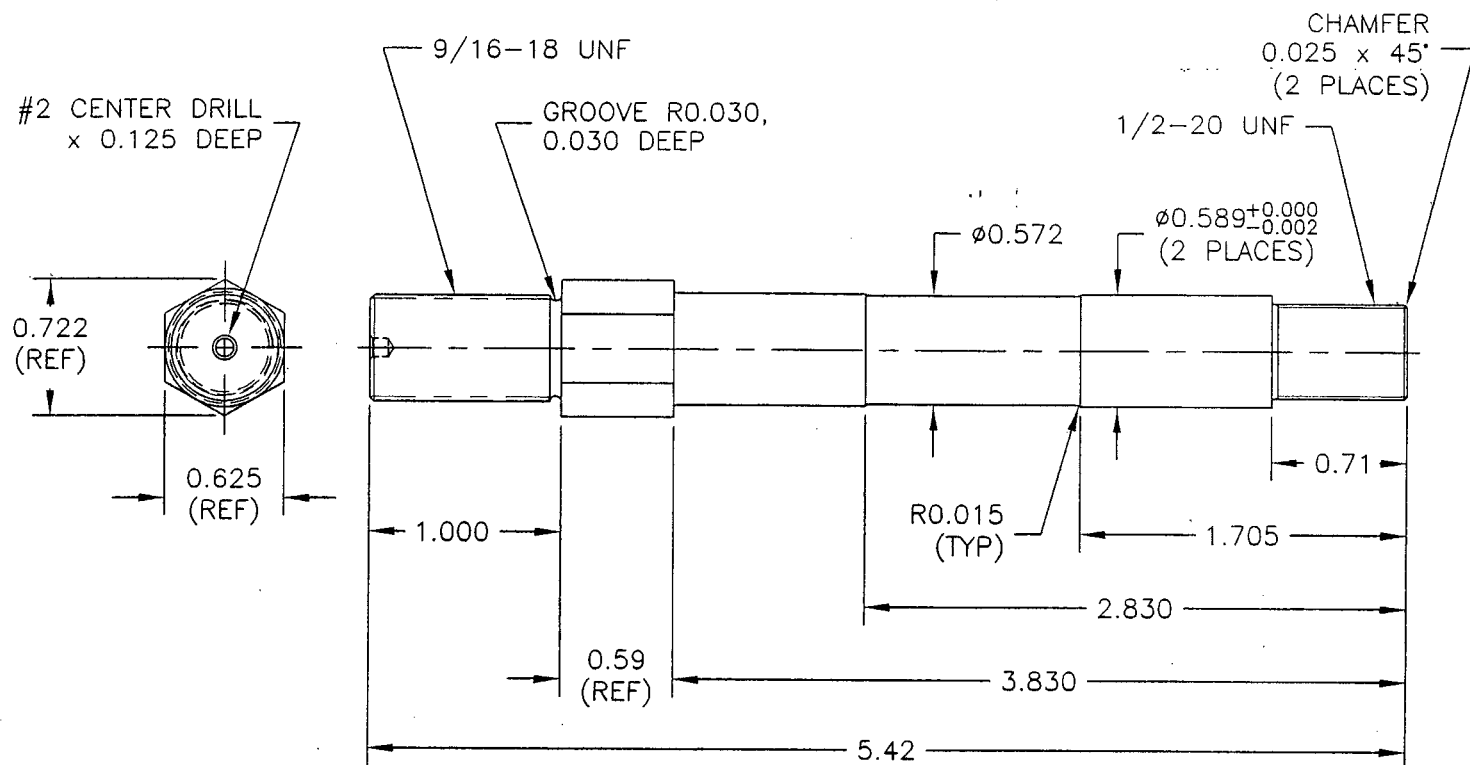
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



|                       |                         |   |                        |
|-----------------------|-------------------------|---|------------------------|
| DESIGN<br>[Signature] | DRAWN BY<br>[Signature] | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>RF         | APPROVED                | DRAWING NO.<br>D3357                              | REV. A<br>SHEET 1 OF 3 |
| DATE<br>04.12.13      | TITLE<br>SHAFTS         |   | SCALE<br>1:1           |
| A                     | 04.12.13                | NEW ISSUE   |                        |

PRELIMINARY ISSUE



D3357-1 R22/R44 WHEEL SHAFT

NOTES:

- 1) MATERIAL: AISI 303 HEXAGONAL BAR STAINLESS STEEL  
(REF. DART SPEC. M303H0.625)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
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WITHOUT NOTICE

WORK ORDER  
NO. 22464

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 15, 2005  
03:37 pm

Work Order No : 0022464  
Project Name : D3357-1  
Project For : WK512  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3357-1  
Description : Wheel Shaft  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 02-15-05  
Est Finish Date : 03-10-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

|                     | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost :     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Engineering Hours : | 0.00      | 0.00   | 0.00   |        |         |
| Engineering Cost :  | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Production Hours :  | 0.00      | 0.00   | 0.00   |        |         |
| Production Cost :   | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Packaging Hours :   | 0.00      | 0.00   | 0.00   |        |         |
| Packaging Cost :    | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| OverHead Hours :    | 0.00      | 0.00   | 0.00   |        |         |
| OverHead Cost :     | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| CNC Hours :         | 0.00      | 0.00   | 0.00   |        |         |
| CNC :               | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Misc. Hours :       | 0.00      | 0.00   | 0.00   |        |         |
| Misc. :             | 0.00      | 0.00   | 0.00   | 0.00   | 0.00    |
| Burden :            | 0.00      | 0.00   | 0.00   |        |         |
| Total Cost :        | 0.00      | 0.00   | 0.00   |        |         |
| Margin :            | 0.000     | 0.000  |        |        |         |
| Selling Cost :      | 0.00      | 0.00   |        |        |         |

|                          | Estimated | Actual |
|--------------------------|-----------|--------|
| Labour Hrs/Amount Done : | 0.00      | 0.00   |
| Profits/(Loss) :         | 0.00      | 0.00   |

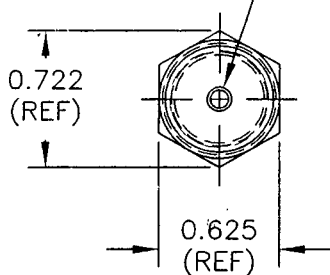




|                      |                       |   |                        |
|----------------------|-----------------------|---|------------------------|
| DESIGN<br><i>43</i>  | DRAWN BY<br><i>43</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>RT</i> | APPROVED<br><i>RT</i> | DRAWING NO.<br>D3357                              | REV. A<br>SHEET 1 OF 3 |
| DATE<br>04.12.13     | TITLE<br>SHAFTS       | SCALE<br>1:1                                      |                        |
| A                    | .04.12.13             | NEW ISSUE   |                        |

RELEASED  
*05/02/22*

#2 CENTER DRILL  
x 0.125 DEEP



9/16-18 UNF

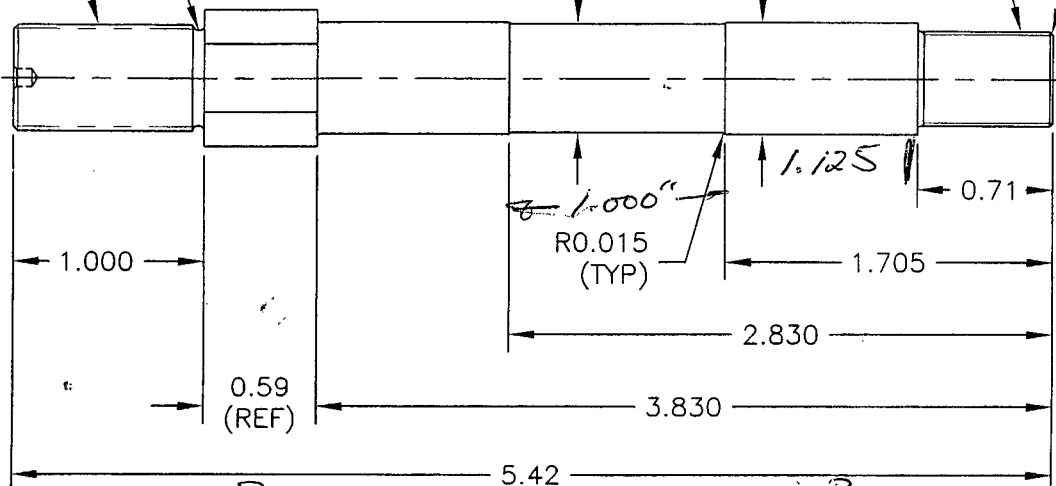
GROOVE R0.030,  
0.030 DEEP

CHAMFER  
0.025 x 45°  
(2 PLACES)

1/2-20 UNF

$\phi 0.589^{+0.000}_{-0.002}$   
(2 PLACES)

$\phi 0.572$



*P1006*  
*1/2-20*  
*SD = .031*  
*8 PASSES*

*P1003*  
*9/16-18*  
*SD = .0034"*  
*8 PASSES*  
*.012" 1<sup>st</sup> PASS*

**D3357-1 R22/R44 WHEEL SHAFT**

**NOTES:**

- 1) MATERIAL: AISI 303 HEXAGONAL BAR STAINLESS STEEL  
(REF. DART SPEC. M303H0.625)
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**REFERENCE ONLY**

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